



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3811-1
Job Sheet 191626



Part No: D3811-1

Job Qty: 10 pcs

Part Name: Seat Track



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/5/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 08-07-31 JLM Verified By:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs		3/18/19	0.00	0.02	Bandsaw - 1		DJP 19-05-10
110	HAAS 4 Axis - B4B	10 pcs		3/18/19	0.95	23.26	HAAS - 1 - B4B		DJP 19-05-10
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	10 pcs		3/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2		
							QC 2 - 5		
							QC 2 - 56		



Container No: S180378



Part: D3811-1

Job No: 191626

Serial No/Batch: S180378

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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Date: 05/10/19

					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
130	Conventional Mill - 1 - B4B	10 pcs	3/18/19	0.00 2.84	Conventional Mill - 1 - B4B	DTP 19-05-10
					Conventional Mill - 2 - B4B	
140	QC 2	10 pcs	3/18/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	DTP 19-05-10
					QC 2 - 54	
					QC 2 - 56	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
150	QC 8	10 pcs	3/18/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	

160 Handfinish - 1-1 Chemical-B4B	10 pcs	3/18/19	0.00 0.76	QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/05/13
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
165 QC 7	10 pcs	3/18/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	

170 Packaging 3-1 - Stock - B4B	10 pcs	3/18/19	0.00	0.00	QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	DAS
					QC 7 - 40	MAY 13 2019 40
					Packaging 3 - 1 - B4B	9-89
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC ST259 610Z
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	MAY 14 2019
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
180 QC 21 - SA	10 pcs	3/18/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89

Part Op 100 - (Bandsaw) Cut blank 23.250 " long

Descriptions: 110 - (HAAS CNC Vertical Machine)1- Mill as per Folio FA776Rev: _____ & Dwg D3811 Rev: _____ 2-Deburr per dwg D3808

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (Manufacture as per dwg) 1-DRILL REMAINING HOLES

140 - (QC2- Inspect parts off machine FAI/FAIB)

150 - (QC8- Inspect parts - second check)

160 - (Chemical Conversion Coat per QSI005 4.1)

165 - (QC7-Inspect Chemical Conversion Coat)

170 - (Identify as per dwg & Stock Location: _____) LOCATION : GA

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	20 ft (2 ea)	100-Bandsaw - 1	S166894

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.500X2.500	20	12	0
Part Specifications				
Specifications could not be found.				

Plex 3/5/19 1:01 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	191626
Description: Seat Track		Part Number:	D3811-1
Inspection Dwg: D3811	Rev: A	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.40	+/-0.030	0.405	✓		Ver	
6.70	+/-0.030	6.70	✓		Ver	
0.700	+/-0.010	0.700	✓		Ver	
1.400	+/-0.010	1.400	✓		Ver	
0.990	+/-0.010	0.992	✓		Ver	
Ø0.281 x 0.44 deep	+0.006/-0.001 x +/-0.030	Ø0.283 x .46	✓		Ver	
0.780	+/-0.010	0.779	✓		Ver	
6.48	+/-0.030	6.48	✓		Ver	
Ø0.196	+0.005/-0.001	Ø0.197	✓		G.P.	
Ø0.388 x 100°	+0.006/-0.001 x 0.5°	Ø0.390 x 100°	✓		Ver	
R0.13	+/-0.030	R.013	✓		R.G.	
0.70	+/-0.030	0.70	✓		Ver	
6.44	+/-0.030	6.44	✓		Ver	
R1.00	+/-0.030	R.1.00	✓		G.P.	
1.576	+/-0.010	1.576	✓		Ver	
1.76	+/-0.030	1.766	✓		Ver	
10.00	+/-0.030	10.00	✓		TAPE	
0.590 pitch	+/-0.010	0.588	✓		Ver	
0.788 pitch	+/-0.010	0.787	✓		Ver	
23.00	+/-0.030	23.00	✓		TAPE	
Ø0.323	+0.006/-0.001	Ø0.323	✓		Gage Pin	
0.27	+/-0.030	0.268	✓		H. Gage	
1.08	+/-0.030	1.077	✓		Vern.	
20.68	+/-0.030	20.68	✓		H.G.	
0.44	+/-0.030	0.46	✓		Vern.	
1.24	+/-0.030	1.238	✓		Vern.	
0.286 x 60°	+/-0.010 x 0.5°	0.288 x 60°	✓		Ver + DAF.	
Ø0.388 x 100°	+0.006/-0.001 x 0.5°	Ø0.390 x 100°	✓		Ver	
R0.032	+/-0.010	R.0.032	✓		R.G.	
0.132	+/-0.010	0.132	✓		Ver	
0.315	+/-0.010	0.315	✓		Ver	
0.015 x 30°	+/-0.010 x 0.5°	0.015 x 30°	✓		Ver	
0.100	+0.030/-0.010	0.108	✓		Mic	
1.98	+/-0.030	1.98	✓		Ver	

DART AEROSPACE LTD		Work Order:	191626
Description: Seat Track		Part Number:	D3811-1
Inspection Dwg: D3811	Rev: A	Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.120	+/-0.010	0.123	✓		Mic.	
0.730	+/-0.010	0.730	✓		D.G.	
0.195	+/-0.010	0.195	✓		Dev	
0.630	+/-0.010	0.631	✓		Dev	

Measured by: DAS 52	Audited by: [Signature]	Prototype Approval:	N/A
Date: 19/05/11	Date: 19/05/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ [Signature]	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					